

Work Order ID 80939

80939

Page 1

March-05-12 3:24:32 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH

Stop *NS2*

Start Date: 05/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/05 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

5/2/07

MLJ 12-4-16

80939

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID. 80939

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 05/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

- ✓ 1- Pick D2600-3 Bent
- ✓ 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750
- ✓ 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.
- ✓ 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting
- ✓ 5- Drill only two fwd step holes using DT9616. Ensure proper positioning.
- ✓ 6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)
- ✓ 7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE
- ✓ 8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)
- ✓ 9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297"
- 10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

SAD 12-03-12

W/O:		WORK ORDER CHANGES					
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Item Name: Skidtube RH

Stop *NS2*

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Required Date: 19/03/2012 Req'd Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left

from bending as per QSI 004

A/R Aluminum Rod batch: *m120164*

BE12/03/13

12-Grind welds flush as per Dwg D2750

SAD

12-03-13

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

S 12/03/13

S 12/03/13

W/O:		WORK ORDER CHANGES					
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Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

① SMO 12-03-12

DP 12-3-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291

batch: M/20/13exp. date: 2012-08-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: M/20/14

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

SAD 12-03-13

CF 12-3-13

BE 12-03-15

CF 12-3-15

BB 12/03/15

W/O:		WORK ORDER CHANGES					
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Start Date: 05/03/2012 Start Qty: 1.00

1

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Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Deburr holes

3 12/03/14

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

5/12/03/15

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

5/12/13/15

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start *NS1*

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Stop *NS2*

Item Name: Skidtube RH

Start Date: 05/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1X M/L 12/03/17

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15

OVEN TEMPERATURE 320

FINISH TIME: 3:45

1 X 12-8-19

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1X M/L 12/03/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March-05-12 3:24:32 PM

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 05/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"
batch: N/A.

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 24 149999

BATCH: 12.8

EXP DATE: 12.8

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 10348

6-Coat all exposed fasteners with "LPS Procyon"
batch: 114596

1 HR 12-3-20 PTO 3)

Dart Aerospace Ltd

W/O: 80939		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/04/11	230	TOUCH-UP ALODINE & IMPROV PART	JL	12/04/11	XL		

Part No: D350-636-012 PAR #: _____ Fault Category: skid-tube NCR: Yes No DQA: JP Date: 12/04/23
12-1367 Resolution: Repair Disposition: Repair QA: N/C Closed: OK Date: 12/4/23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/11	# 220	Found that 1st Aft hole is pl and want allow the belt to pass through skid + blade fitting.	JP 12.04.11	open holes up to 0.520" - 0.530"	JP 12-4-11	S 12/04/17	JP 12.04.11	S 12/04/11
		RC. Process / Human error	JP 12.04.11	touch up ALODINE as per Q51000 and apply to white primer to hole.	JP 12/04/11		JP 12.04.11	S 12/04/11

NOTE: Date & initial all entries

Work Order ID 80939

March-05-12 3:24:32 PM

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Item ID: D350-636-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 05/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date 12/17/17

Handwritten signature and date 12/17/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 80939

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Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube RH

Start Date: 05/03/2012 Start Qty: 1.00

1

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Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Package as per PPP D350-636-012

Packaging

Rev F

IX

SP

12-04-17

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/4/19

12-04-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 80939

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

15.0000

1

1

D2600-3-BENT

**

SAD

12-03-13

Extrusion Bent

Location

Loc Qty

Loc Code

LG

15

66875

7

73253

1

75021

1

75022

1

75023

1

79497

4

D2744

Manufactured

No

110

Each

62.0000

1

1

D2744

**

BE 12/03/13

Cap

Location

Loc Qty

Loc Code

LG002

62

62715

1

70881

12

71861

7

78900

42

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No

160 Each

11.0000 1 1

D2739

350 I Beam

**

1

CF 12-3-13

Location

Loc Qty

Loc Code

LG

11

72155

1

80083

10

D2743 Manufactured No

160 Each

264.0000 8 8

D2743

Crossbolt Spacer

**

BE 12/03/15

Location

Loc Qty

Loc Code

LG001

264

67766

4

68251

3

73403

64

74445

1

78603

92

79517

100

D3490-3 Manufactured No

160 Each

46.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE 12/03/15

Location

Loc Qty

Loc Code

LG001

46

77567

6

78800

40

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160 Each

57.0000 - 4 4

D3490-1

**

Cross Bolt Spacer

BE12/03/15

Location

Loc Qty

Loc Code

LG001

57

62450

2

74875

4

77042

8

78793

43

4

D3631-1 Manufactured No

230 Each

223.0000 8 8

D3631-1

**

Washer

BL12-3-21

Location

Loc Qty

Loc Code

ST072

223

68062

2

75548✓

221

8

D3791-1 Manufactured No

230 Each

17.0000 1 1

D3791-1

**

Wearplate

BL12.3.21

Location

Loc Qty

Loc Code

FP002

17

62239

2

75041✓

3

78897

12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No

230

Each

26.0000

1

1

D3793-3

**

Wearshoe

BL 12-3-21

Location

Loc Qty

Loc Code

FP001

12

80434

12

FP002

14

78935 ✓

14

MS21043-6 Purchased No

230

Each

817.0000

4

4

MS21043-6

**

NUT

BL 12-3-21

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

797

112314 ✓

87

117887

10

118384

200

120308

500

D3794-1 Manufactured No

230

Each

12.0000

1

1

D3794-1

**

Gasket

BL 12-3-21

Location

Loc Qty

Loc Code

FP002

12

75042 ✓

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-05-12 3:24:37 PM

Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

167.0000

8

8

NAS1611-010

O-RING

BL12-3-25

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

117

110915

14

117460

8

118077

1

118612

3

119438

47

120308 ✓

44

8.

D2741

Manufactured

No

250

Each

37.0000

1

1

D2741

Blade, 350 Skidtube

[Signature]

Location

Loc Qty

Loc Code

ST

-10

ST466

47

71856

1

76984

36

76984

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

216.0000

4

4

***NAS1515H3I ***

**

BL 12.3.2L

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

176

118686

3

119438

1

120072 ✓

72

120360

100

H

NAS1611-013

Purchased

No

230

Each

176.0000

8

8

NAS1611-013

**

BL 12.3.21.

O-RING

Location

Loc Qty

Loc Code

FP001

176

116582

5

117291

2

117887

53

119623

36

120360 ✓

30

120910

50

S

March-05-12 3:24:37 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

672.0000

4

4

AN3C6A

BOLT

*******BR 12321*LocationLoc QtyLoc Code

FP001

1

111982

1

ST351

671

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423 ✓

182

120693

400

14

NAS1149C0832R

Purchased

No

230

Each

305.0000

1

1

NAS1149C0832R

WASHER

*******BR 12321*LocationLoc QtyLoc Code

ST297

305

114915 ✓

305

D3536-25

Manufactured

No

230

Each

16.0000

1

1

D3536-25

Gasket

*******BR 12321*LocationLoc QtyLoc Code

FP002

16

78902 ✓

16

1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230

Each

7.0000

1

1

D3794-3

Gasket

**

BL12-3-21

Location

Loc Qty

Loc Code

FP002

7

74530

2

78895 ✓

5

AN3C5A

Purchased No

230

Each

1,010.000

34

34

AN3C5A

Bolt

**

BL12-3-21

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1003

116419

28

117343

13

117764

7

117872

2

119749

23

120423 ✓

930

D3537-1

Manufactured No

230

Each

57.0000

3

3

D3537-1

Wearpad

**

BL12-3-21

Location

Loc Qty

Loc Code

FP001

4

78592

4

FP002

53

69817

5

79834

48

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

19.0000

1

1

D3535-25

Wearshoe

**

BL 12-3-21

Location

Loc Qty

Loc Code

FP001

14

62233

1

80331

13

FP002

5

77617 ✓

5

1

D3492-3

Manufactured No

230

Each

77.0000

8

8

D3492-3

Plug

**

BL 12-3-21

Location

Loc Qty

Loc Code

FP002

1

77039

1

FP-A

76

78600 ✓

76

8

AN960C10L

**R*

NAS1149C0332 ✓ Purchased

No

230

Each

0.0000

38

38

***AN960C10I ***

washer

120648

**

38. BL 12-3-21

D3488-042

Manufactured No

230

Each

20.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

BL 12-3-21

Location

Loc Qty

Loc Code

FP002

20

62003

1

71883

1

75068

9

77015 ✓

9

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,194.000

38

38

AI S4-1032-225

Insert

**

BR 12-3-22

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

163

120410 ✓

150

120451

13

4

D3492-1

Manufactured

No

230

Each

138.0000

8

8

D3492-1

Plug

**

BR 12-3-21

Location

Loc Qty

Loc Code

FP002

138

69531

8

74444

2

76235 ✓

28

77037

100

8

D3793-1

Manufactured

No

230

Each

18.0000

1

1

D3793-1

Wearshoe

**

BR 12-3-21

Location

Loc Qty

Loc Code

FP001

18

77029 ✓

6

78901

12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

66.0000

1

1

AN8C35A

BOLT

**

BL 12-3-21

Location

Loc Qty

Loc Code

FP002

65

115960

1

117834 ✓

10

118286

54

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

67.0000

1

1

MS21083C8

NUT

**

BL 12-3-21

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

15

115884

0

118077

1

119309

2

119436 ✓

10

119638 ✓

2

ST304

51

120142

26

120731

25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 80939

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

80939

D350-636-012

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

44.0000

8

8

D2745

Bushing

**

BL 12.3.21.

Location

Loc Qty

Loc Code

FP001

44

69529

1

76142

1

78597 ✓

42

AN6C44A

Purchased No

230

Each

95.0000

4

4

AN6C44A

BOLT

**

BL 12.3.21.

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

93

120095 ✓

16

120143

25

120465

27

120641

25

D3532-1

Manufactured No

250

Each

39.0000

2

2

D3532-1

Spacer

**

12/7/17

Location

Loc Qty

Loc Code

ST053

39

78839

39

78839

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 80939

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

80939

D350-636-012

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

67.0000

2

2

MS21083C8
NUT

**

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

15

115884

0

118077

1

119309

2

119436

10

119638

2

ST304

51

120142

26

120731

25

NAS1149D0863J

Purchased

No

250

Each

231.0000

2

2

NAS1149D0863J
WASHER

**

Location

Loc Qty

Loc Code

ST298

231

118078

36

119307

95

120308

100

D3493-1

Manufactured

No

250

Each

66.0000

2

2

D3493-1
Washer

**

Location

Loc Qty

Loc Code

ST050

66

70697

2

77573

24

78835

40

March-05-12 3:24:38 PM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 80939

80939

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

57.0000

2

2

**

AN8C21A
BOLT

Location

Loc Qty

Loc Code

ST343

57

118758

5

120094

42

120872

10

120872

12/4/12 ①
SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1		D3488-041	BLADE FITTING, LH
			1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 80939 MLJ
12/03/05

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/RAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NOR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F
SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

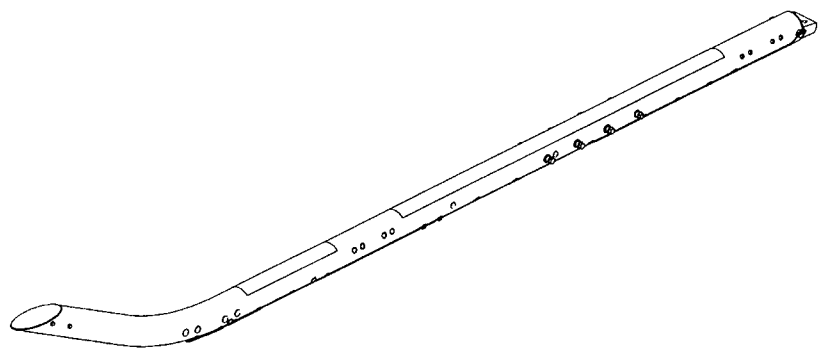
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

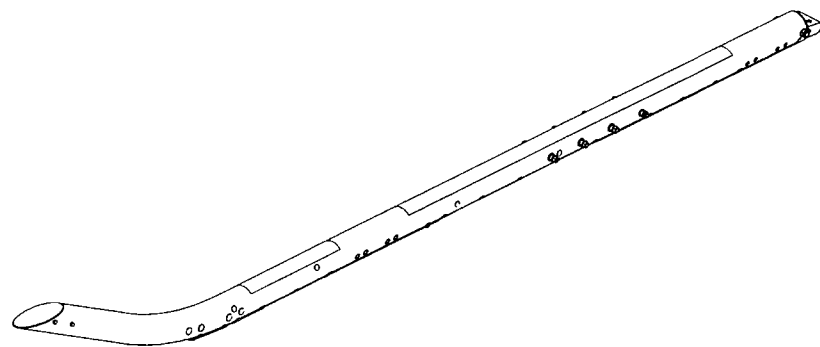
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80939



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-22-11

DESIGN	PCW	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, VA	
CHECKED	RA	DRAWING NO. D2750	REV. F
MFG. APPR.	RA	SHEET 2 OF 11	
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

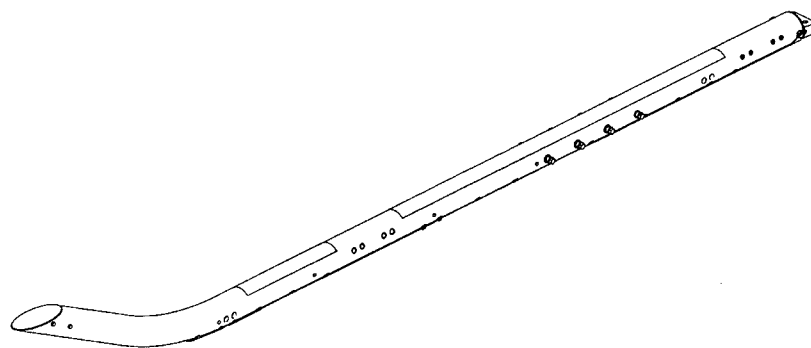
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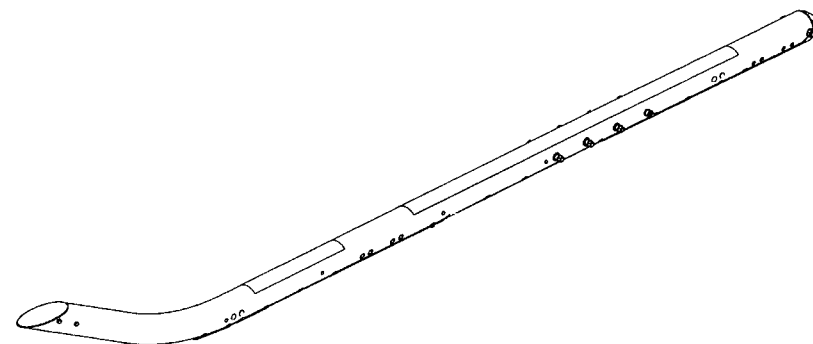
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

809:39



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-09-22-1-11

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

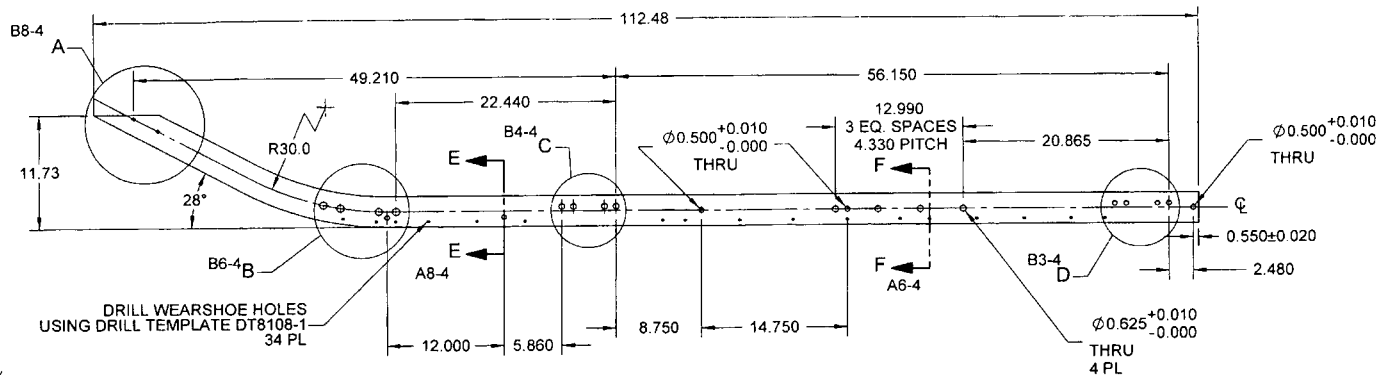
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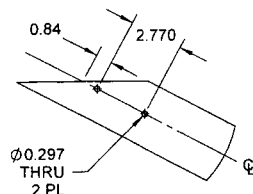
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

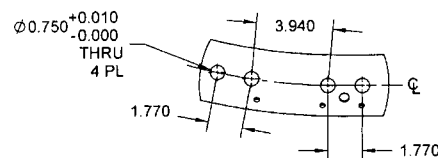
80939



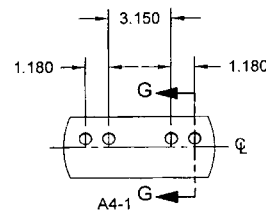
D2750-1 LH SKIDTUBE



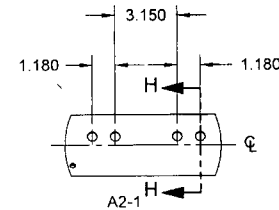
DETAIL A
SCALE 2X



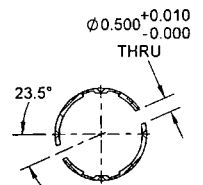
DETAIL B
SCALE 2X



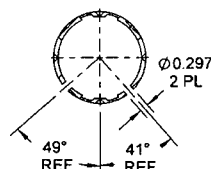
DETAIL C
SCALE 2X



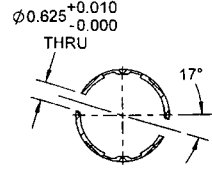
DETAIL D
SCALE 2X



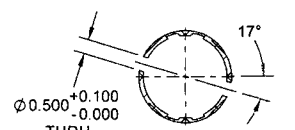
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

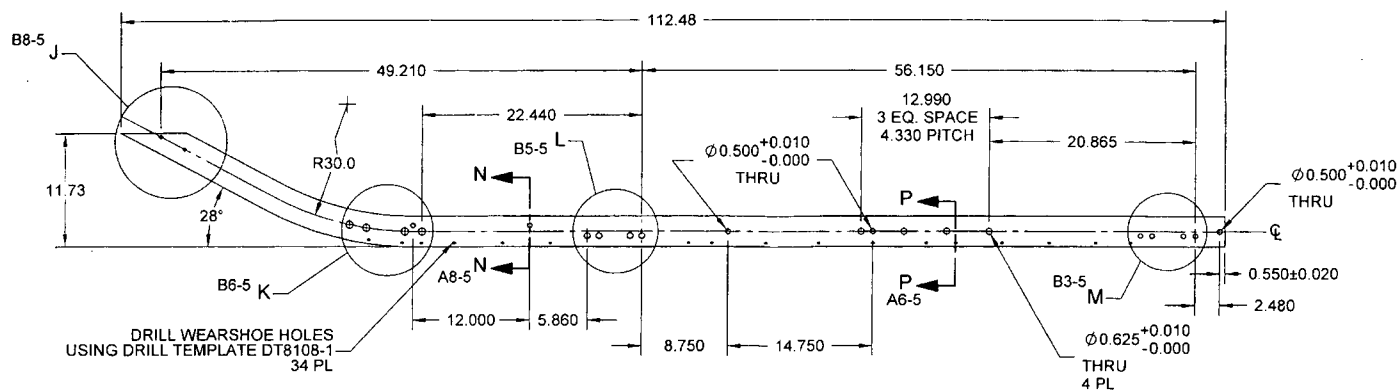
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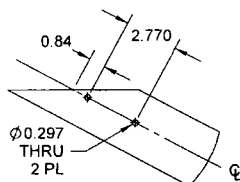
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

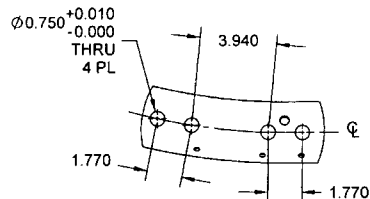
80939



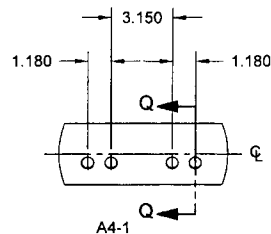
D2750-2 RH SKIDTUBE



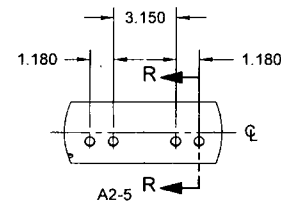
DETAIL J
SCALE 2X



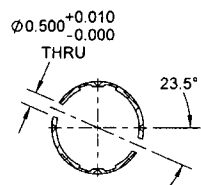
DETAIL K
SCALE 2X



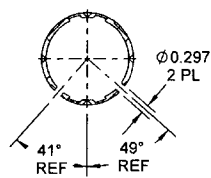
DETAIL L
SCALE 2X



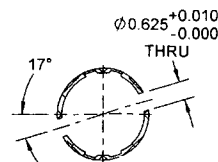
DETAIL M
SCALE 2X



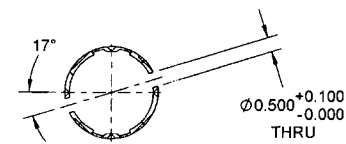
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	PE	DART AEROSPACE USA, INC.	
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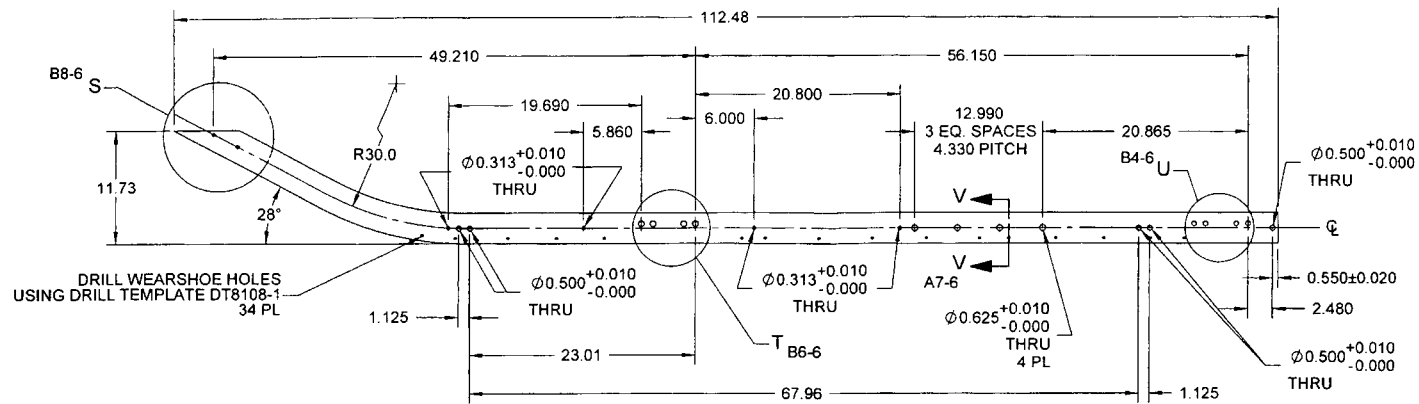
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

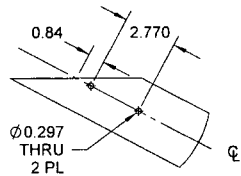
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

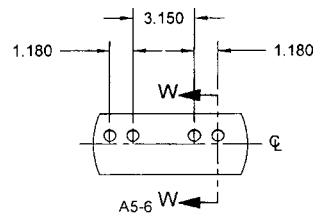
NOTE: Date & initial all entries



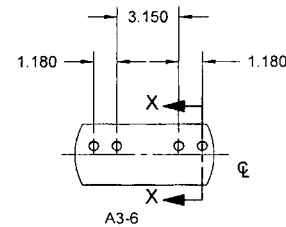
D2750-3 LH SKIDTUBE



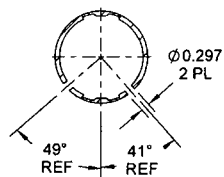
DETAIL S
SCALE 2X



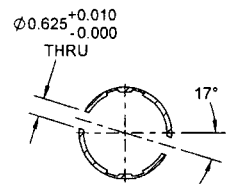
DETAIL T
SCALE 2X



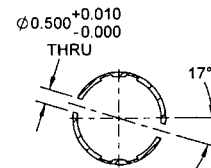
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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08-07-16

DESIGN		DART AEROSPACE USA, INC.	
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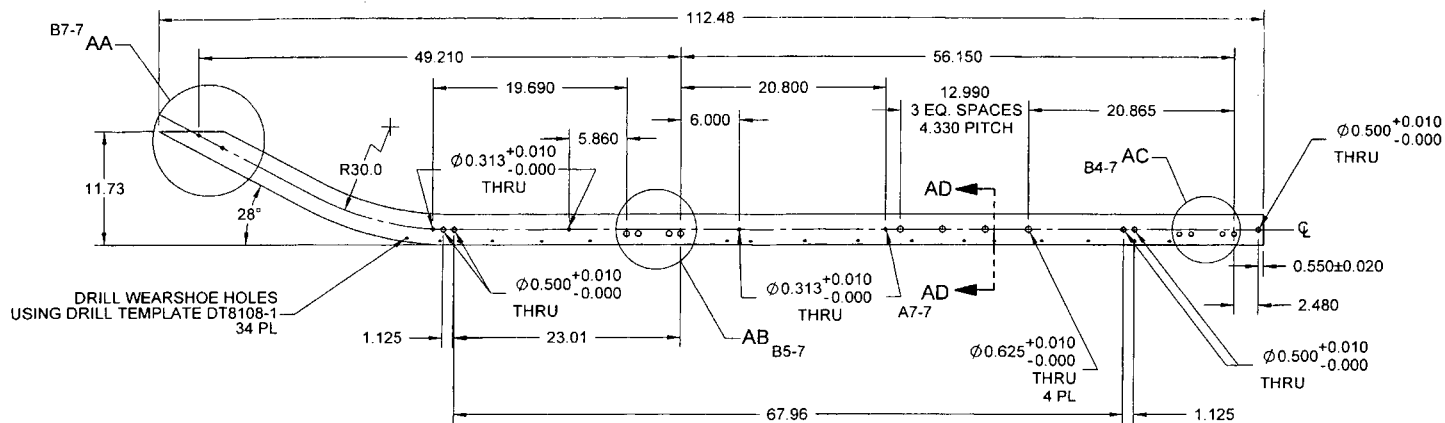
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

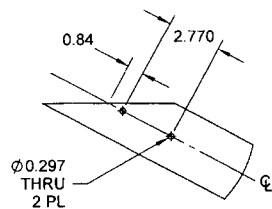
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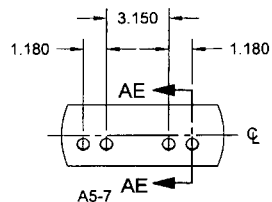
NOTE: Date & initial all entries



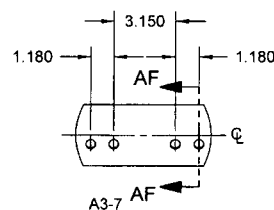
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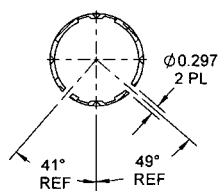
DETAIL AA
SCALE 2X
D7-7



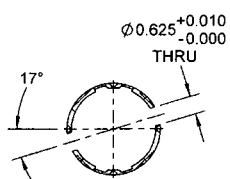
DETAIL AB
SCALE 2X
C4-7



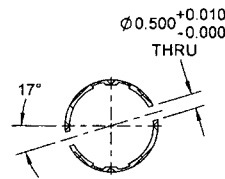
DETAIL AC
SCALE 2X
D3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

RELEASED
08-09-2016

DESIGN	PG	DART AEROSPACE USA, INC.	
DRAWN	PG	PORT HADLOCK, WA	
CHECKED	PG	DRAWING NO. D2750	REV. F
MFG. APPR.	PG	SHEET 7 OF 11	
APPROVED	PG	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

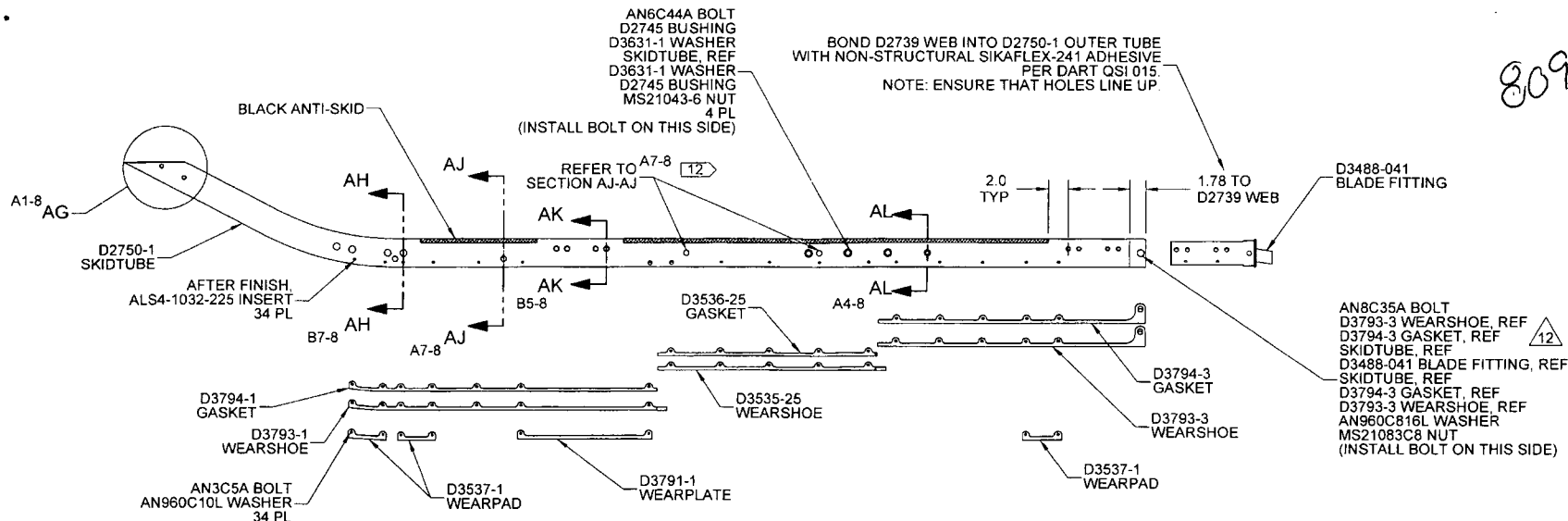
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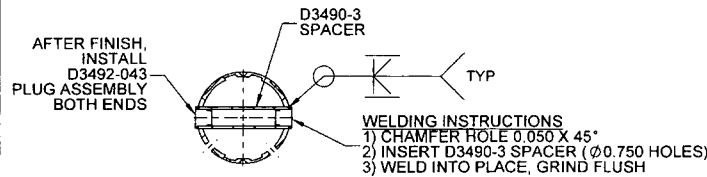
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

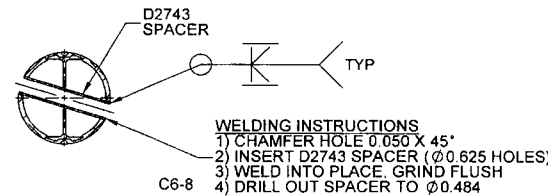
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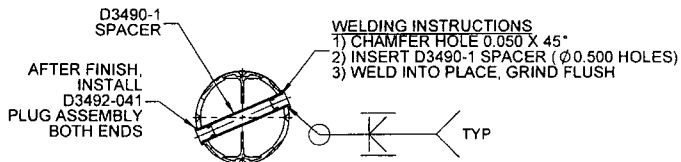
D2750-041 350 SKIDTUBE ASSEMBLY, LH



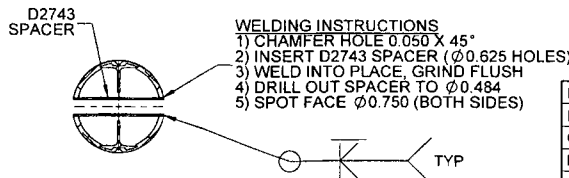
SECTION AH-AH
SCALE 3X, 4 PL



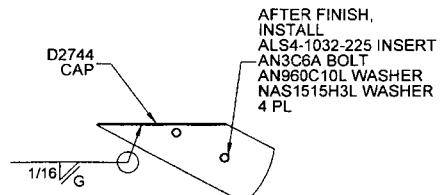
SECTION AK-AK
SCALE 3X, 4 PL



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AG
SCALE 2X

RELEASED
D8-8
08-07-16

DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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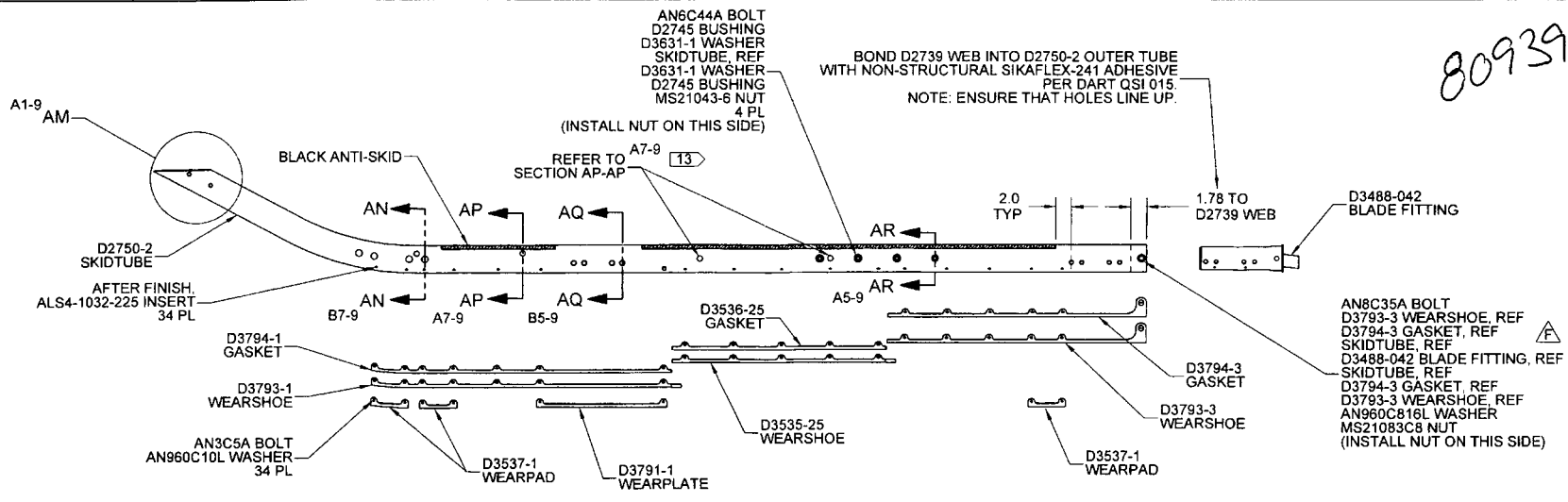
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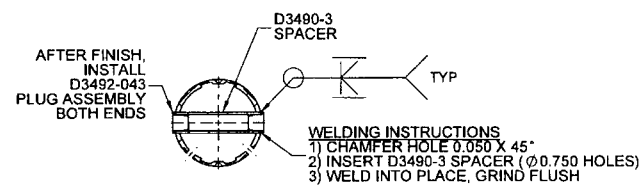
NOTE: Date & initial all entries

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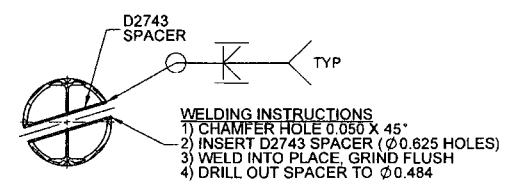
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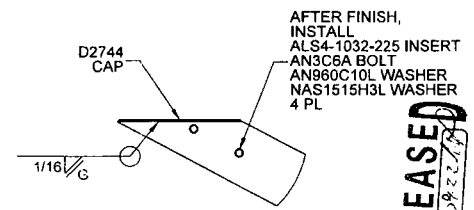
D2750-042 350 SKIDTUBE ASSEMBLY, RH



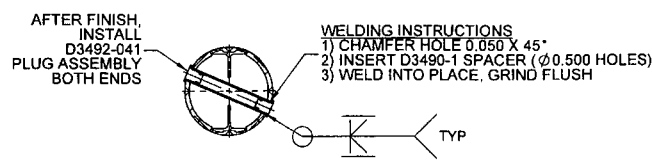
SECTION AN-AN
SCALE 3X, 4 PL



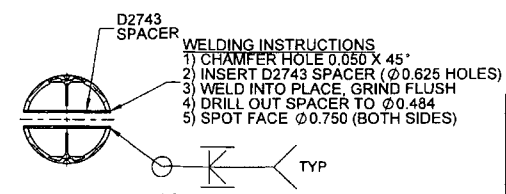
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	AC	DRAWING NO.	REV. F
MFG. APPR.	MD	D2750	SHEET 9 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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08-04-2016

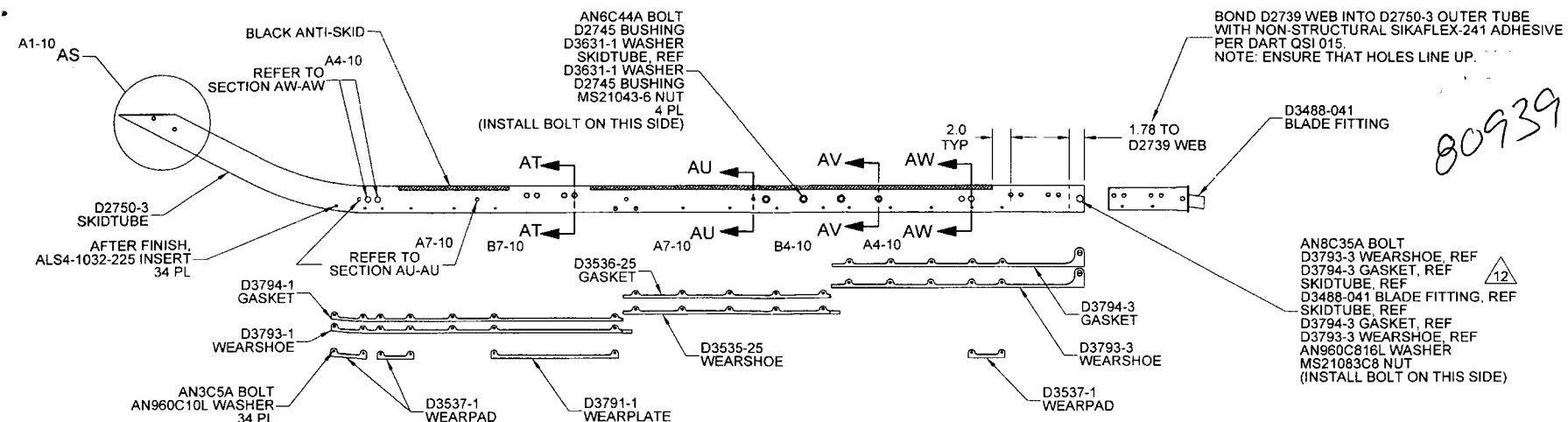
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

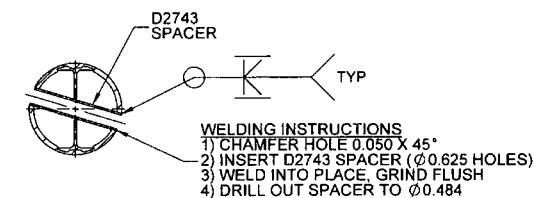
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

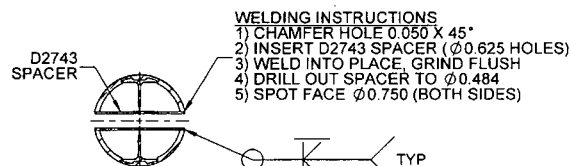
NOTE: Date & initial all entries



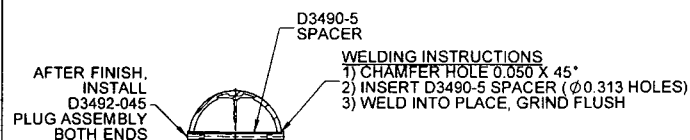
D2750-043 350 SKIDTUBE ASSEMBLY, LH



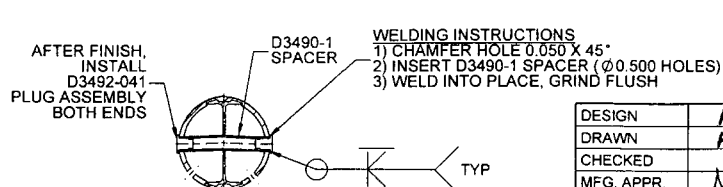
SECTION AT-AT SCALE 3X, 4 PL



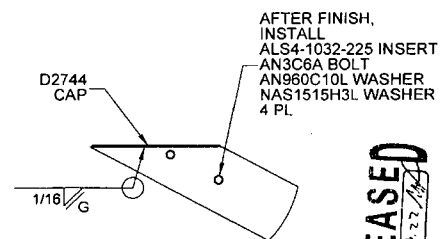
SECTION AV-AV SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU SCALE 3X, 4 PL



SECTION AW-AW SCALE 3X, 4 PL



DETAIL AS SCALE 2X

DESIGN	REV. 1	DART AEROSPACE USA, INC.	
DRAWN	REV. 1	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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08.07.16

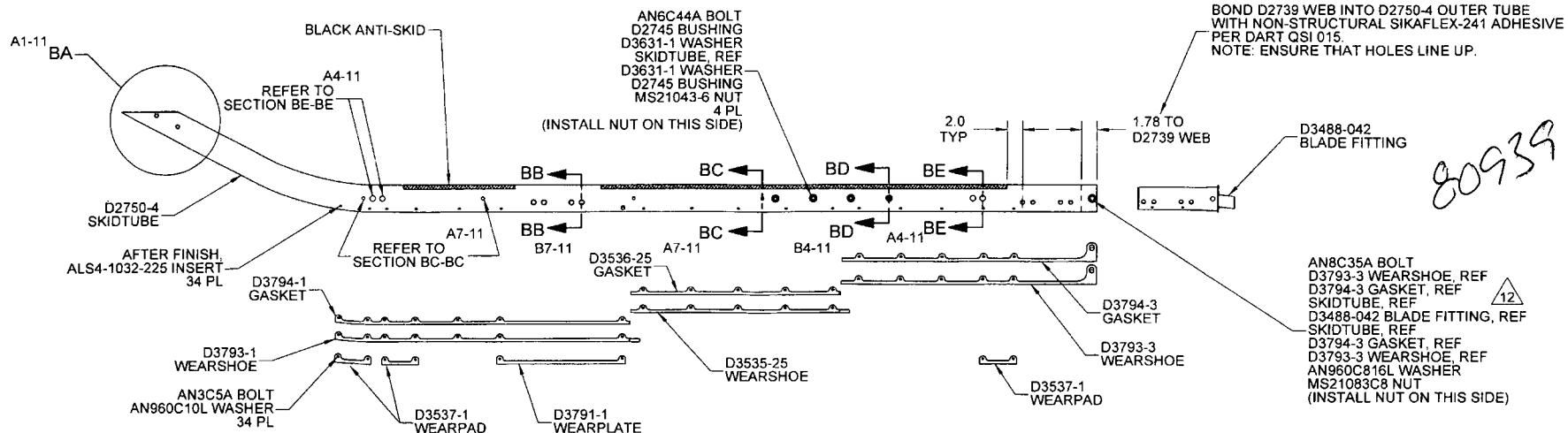
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

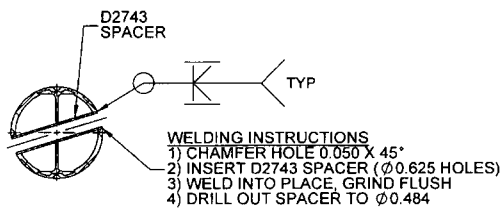
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

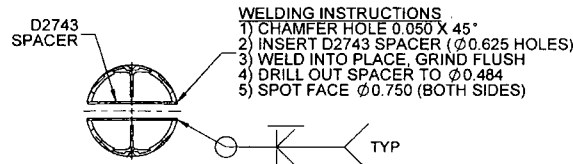
NOTE: Date & initial all entries



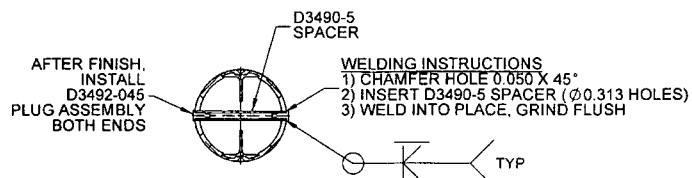
D2750-044 350 SKIDTUBE ASSEMBLY, RH



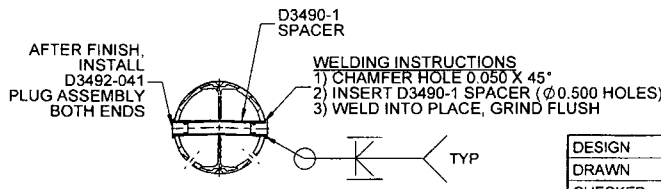
SECTION BB-BB SCALE 3X, 4 PL



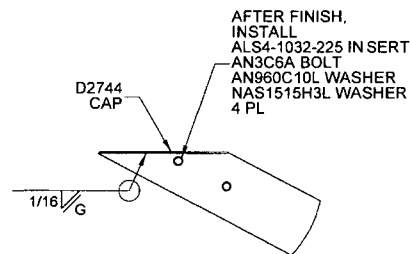
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 11 OF 11
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DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 282

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 78413
Part number: A350-636-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Newell Date of Test Coupon 12.02.01
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld